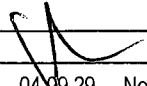


Canadian Heli
 Date: Tuesday, 06/05/2008 7:17:31 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR 212/412
Job Number :	39062		
Estimate Number :	10887		
P.O. Number :		Part Number :	D412711011
This Issue :	06/05/2008	Drawing Number :	N/A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	N/A
Previous Run :	38682	Material :	
Written By :		Due Date :	23/05/2008
Checked & Approved By :		Qty:	1
Comment :	Est Rev:A 04.09.29 New issue KJ/JLM	Um:	Each
Type : PURCHASED PARTS			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

JLD
08.5.06

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 6304 to Eagle Copters

"Assembly of D412-711-011 Door

Send a copy of this IPP

c 208/05/06 ①

3.0	D412711041	Vertical Reference Door Assembly
-----	------------	----------------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0	D412711101	Replacement Bubble Window
-----	------------	---------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0	D412711111	Wiring Harness, 212/412
-----	------------	-------------------------

**Comment:** Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D412-711-111 Wiring Harness, 212/412

Date: Tuesday, 06/05/2008 7:17:31 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 39062

Part Number: D412711011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	EA2046915412	Instrument Panel, 412
-----	--------------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

7.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	EB212-100L / EA20469-3	Window	
---	------------------------	--------	--

1	EA20469-05	Rubber Strip	
---	------------	--------------	--

1	EA20469-06	Aluminum Strip	
---	------------	----------------	--

1	EA20469-07	Angle	
---	------------	-------	--

1	EA20469-08	Placard	
---	------------	---------	--

1	EA20469-10	Rear Rib Assy	
---	------------	---------------	--

1	EA20469-11	Angle	
---	------------	-------	--

1	EA20469-12	Fwd Rib	
---	------------	---------	--

1	EA20469-13	Window	
---	------------	--------	--

1	EA20469-14	Window Retainer	
---	------------	-----------------	--

1	EA20469-16	Armrest Assy	
---	------------	--------------	--

1	EA20469-17	Angle	
---	------------	-------	--

1	EA20469-18	Door Inner Skin	
---	------------	-----------------	--

1	EA20469-21	Door Cover Panel	
---	------------	------------------	--

2	EA20469-23	Link	
---	------------	------	--

1	EA20469-24	Rod	
---	------------	-----	--

1	EA20469-25	Arm Assy	
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Material Certification / Proof of Traceability / Certificate of Conformity required

Date: Tuesday, 06/05/2008 7:17:31 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 39062

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt _____

22 AN3-4ABolt _____

24 AN3-7ABolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Tuesday, 06/05/2008 7:17:31 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 39062

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

